

Date: Thursday, 4/12/2007 8:44:56 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	31717					
Estimate Number	10533					
P.O. Number	N/A			Part Number	D2573	
This Issue	4/12/2007			Drawing Number	D2573 REV E	
Prsht Rev.	NC			Project Number	N/A	
First Issue	N/A			Drawing Revision	E	
Previous Run	30594			Material	N/A	
Written By				Due Date	4/30/2007	
Checked & Approved By	9/07/04.12			Qty:	12	Um: Each
Comment	Est: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>325354</u> <u>X12</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>331717</u> Double check by: <u>SC</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	 <u>MS/SC or los/los</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <u>MS/SC or los/los</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 <u>MS/SC or los/los</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/05/11
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:44:56 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 31717

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 07/05/08

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL

07/05/09 (12)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



(12X)

m-l 07/05/09

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EP 07/05/10



9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/05/10 (12)



10.0 QC21 FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

EP 07/05/11

Job Completion



U 07/05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 31717	
Description: Saddle, Aft Outboard				Part Number: D2573	
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.750	1.749		
C	3.495	3.505		3.499	3.500	3.499	3.499		
D	1.745	1.755		1.749	1.748	1.750	1.749		
E	7.990	8.010		8.004	8.003	8.003	8.004		
F	0.490	0.510		0.497	0.496	0.499	0.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.502	0.503	0.502		
J	1.174	1.184		1.177	1.176	1.179	1.177		
K	0.558	0.578		0.562	0.566	0.565	0.565		
L	1.174	1.184		1.177	1.176	1.179	1.177		
M	1.365	1.375		1.367	1.368	1.366	1.366		
N	2.495	2.505		2.498	2.496	2.497	2.498		
O	4.119	4.129		4.121	4.124	4.121	4.121		
P	0.115	0.135		0.128	0.127	0.128	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.252	0.253	0.252		
S	0.115	0.135		0.129	0.126	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.242	0.242	0.239		
W	0.115	0.135		0.132	0.135	0.131	0.129		
X	0.308	0.313		0.310	0.310	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.362	0.362	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.625	0.627	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.250	0.249	0.250		
AE	1.500	1.520		1.512	1.512	1.513	1.513		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.261		
AH	0.240	0.260		0.252	0.257	0.249	0.248		
AI	2.000	2.020		2.002	2.002	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	SN	Audited by:	RA
Date:	07.05.05	Date:	07.05.06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK

DART AEROSPACE LTD				Work Order:	31717
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

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Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
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B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.499	3.500	3.500	3.497		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.002	8.003	8.004	8.001		
F	0.490	0.510		0.501	0.503	0.498	0.497		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.503	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.175	1.177		
K	0.558	0.578		0.566	0.566	0.565	0.567		
L	1.174	1.184		1.179	1.179	1.175	1.177		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.497	2.497	2.499		
O	4.119	4.129		4.122	4.121	4.121	4.123		
P	0.115	0.135		0.126	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.251	0.252	0.252		
S	0.115	0.135		0.127	0.127	0.130	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250	3.230	3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.238	0.240	0.240		
W	0.115	0.135		0.129	0.129	0.133	0.131		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.624	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.246	0.247	0.249		
AE	1.500	1.520		1.512	1.512	1.512	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.266	0.260		
AH	0.240	0.260		0.250	0.257	0.250	0.249		
AI	2.000	2.020		2.001	2.001	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.032		
Accept/Reject									

Measured by: *CD*
Date: *07/05/06*

Audited by: *SM*
Date: *07/05/06*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>CD</i>	<i>SM</i>

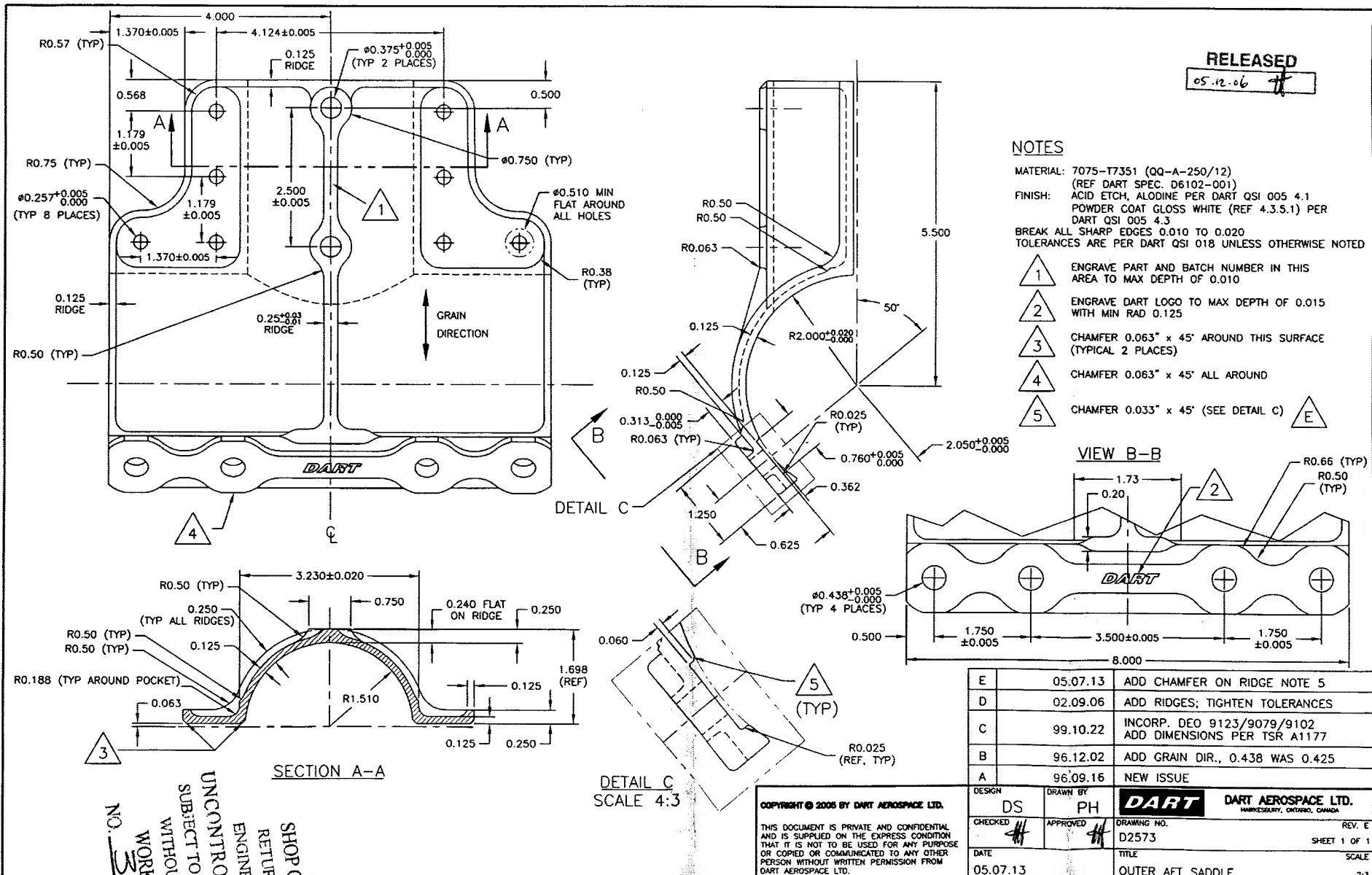
DART AEROSPACE LTD				Work Order:	31717
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

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C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.749	1.748	1.748		
E	7.990	8.010		8.003	8.001	8.001	8.001		
F	0.490	0.510		0.501	0.502	500	500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.501	.500	.500		
J	1.174	1.184		1.178	1.175	1.179	1.179		
K	0.558	0.578		0.566	0.566	.565	.565		
L	1.174	1.184		1.178	1.175	1.178	1.178		
M	1.365	1.375		1.366	1.367	1.367	1.367		
N	2.495	2.505		2.497	2.497	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.122	4.122		
P	0.115	0.135		0.126	0.128	.128	.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	.252	.252		
S	0.115	0.135		0.123	0.127	.125	.125		
T	0.178	0.198		0.189	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.237	.238	.238		
W	0.115	0.135		0.132	0.132	.132	.132		
X	0.308	0.313		0.310	0.310	.312	.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.365	.368	.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.628	.628	.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	.248	.248		
AE	1.500	1.520		1.512	1.513	1.517	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	.251	.251		
AI	2.000	2.020		2.002	2.003	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EP / MS	Audited by:	J.L
Date:	07/05/08	Date:	07/05/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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NO. 31717

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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DART		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DRAWING NO.	REV. E	
02573	SHEET 1 OF 1	
TITLE	SCALE	
OUTER AFT SADDLE	21	

